



### **Abstract of the Disclosure**

A plasma arc cutting process for cutting a metal workpiece, in which a dual-gas-flow torch fitted with an electrode with an emissive insert is used, the torch delivering a central gas stream and an annular gas stream, the annular stream being delivered peripherally to the central gas stream, the central gas stream contains a hydrogen-nitrogen mixture and the peripheral gas stream contains carbon dioxide. The invention also relates to a unit utilizing such a torch.